QC2- Inspect parts off machine FAI/FAIB

Memo

110

\*11**0**\*

Quality Control

Work Orde		655		*956				Page 1			
Revision ID:	D2002-015		·	Accept	*N900	<b>04</b> 0	1100	<b>)</b> * s	- Setup Sta	1/1	S1*
Required Date: 1/30/13 Req'd		Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*		Cust Item ID: Customer:				Sto	<sup>op</sup> *N	S2*
Approvals:	Process Plan:MLJQC:		Date: 12-01-10		Date:			F	Run Sta	1/1	R1*
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D2002	Revi Rev	sion Nbr A						<b>V</b> -1	<b>Q</b> 1/J	Number	Stamp
*100 *100* Doosan Doosan Lathe		Memo		0.00 .: 0.00	13.2	. \		20	ф		0As 04 289

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												DQA:	Da	te: _	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	NANCE / UI	PDATE					
		··										QA Closed:	Da	te:	
Work Orde	or.					DISPOSITION			!	DE	PARTMENT	/PROCESS			
Work Ord	٠					Rework	7		Skid-tube	Crosstube		]	Water Jet		Engineering
Part I	No.					Scrap	1	Machining Small Fab			-	<del></del>			Quality
	•					Use-as-is	1	Thern	noforming	Finishing		<b>→</b>			Other
NCR I	No.					Work Order Update	]		Large Fab	Composite			Supplier		
				1	,		- T	L		· · · · · · · · · · · · · · · · · · ·		T			
Root		_		_	1	ption of work order update		Initial		ction		Sign &			
Cause					<u> </u>	or Non-conformance	Cr	nief Eng	Des	cription		Date	Verificatio	n	QC Inspector
Doc/Data	Ш														
Equip/Tooling	Ш								!						
Operator	Ш								ı						
Material	Ш														
Setup	Ш						1								
Other	Ш														
Process							İ							- 1	
Supplier															
Training															
Unapproved									J						
						F	AUI	LT CATE	GORY						
Landi	ng G	iear				General		_				_			
	Bending				Bend		Grain				Ovalized			Pressure/Forced	
	Centre Not Concentric to O/S			o/s	BOM/Route		Hardwa	re ,			Over/Under	tolerance		Temperature/Cure	
		Cracks				Broken/Damaged		Inspecti	on incomplete			Part Incorre	ct	$\Box$	Weld
10	Crushed/Crimped				Burrs		Instruct	ions Incomplete	e/Unclear		Part Lost/M	issing	П	Wrong Stock Pulled	
	П	Cuffs				Contamination		Mainte	nance			Part Moved			•

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

January-16-13 8:36:06 AM

Page 2

Item ID: D2002-015 Accept \*N900040100\* Setup Start Revision ID: Item Name: Knob Start Date: 1/16/13 **Start Oty: 20.00 Cust Item ID:** Required Date: 1/30/13 Reg'd Oty: 20.00 **Customer:** Reference: Run Approvals: Process Plan: Date: Tooling: Date: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool # Plan Tool ID Accept Reject Reject Insp. Work Center ID Description **Run Hours** Qty Code Qty Number Stamp 120 OC8- Inspect parts - second check 0.00 \*120\* 13-2-2 QC 0.00 Memo **Quality Control** Identify as per dwg & Stock Location 130 0.00 Packaging 0.00 Memo Packaging 140 QC21- Final Inspection - Work Order Release 0.00 \*140\* 0.00 Memo Quality Control

AB024

												DQA:	Da	ate: _	
NCR:	Yes /	No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE					
								_				QA Closed:	D	ate:	
Work Orde	er.					DISPOSITION				AGAINST	DE	PARTMENT	PROCESS		
Part f	 No					Rework Scrap Use-as-is Work Order Update	Machining Sma Thermoforming Fini			Crosstube Small Fab Finishing Composite		<b></b> i			Engineering Quality Other
Root					Descri	ption of work order update		Initial	Ad	tion		Sign &			
Cause					(	or Non-conformance	Ct	Chief Eng Description				Date	Verification	on :	QC Inspector
Doc/Data	Ш								:						
Equip/Tooling														- 1	
Operator	Ш														
Material															
Setup															-
Other															Ti.
Process															
Supplier	П													1	
Training															
Unapproved															
						F	AUI	LT CATE	GORY						
Landi	ng Gea	r			-	General									
	Bending				Bend	Г	Grain				Ovalized			Pressure/Forced	
	Centre Not Concentric to O/S			o/s	BOM/Route		Hardwa	re '			Over/Under	tolerance		Temperature/Cure	
	Cr	acks				Broken/Damaged		Inspecti	on Incomplete		Г	Part Incorre	ct		Weld
	Cr	ushed/0	Crimped,			Burrs		Instruct	ions Incomplete,	/Unclear	Г	Part Lost/Missing			Wrong Stock Pulled
	Пcu		•			Contamination		Maintenance				Part Moved	-		-

Out of Calibration

Out of Sequence

Outside Dirnensions

Mislabeled<sup>1</sup>

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

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## **Picklist Print**

January-16-13 8:36:09 AM

Work Order ID: 95655

Parent Item:

D2002-015

Parent Item Name: Knob

\*95655\* \*D2002-015\* Page 1

**Start Date: 1/16/13** 

Required Date: 1/30/13

**Start Qty: 20.00** 

Required Qty: 20.00

Comments:

IPP C00.05.18Added inspection level 8EC

IPP Rev:D Now on Doosan Lathe, ILM, Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand		Total Qty	Qty Issued	Date Issued	Status
MDELRINR1.2500		Purchased	No				f	15.3400		1			
*MDFLRIN DELRIN ROUND BAR 1.2		)()*		<u>Location</u>		<u>Loc Q</u>	<u>etv</u>	Loc Code	**	· · · · · · · · · · · · · · · · · · ·	3.2	- )	04 04 89
				MAT018		15	.34					* *	
					119133	1	.84		<del></del>		_		
					121971	C	.06				_		
					122582	13	.44			1	_		

		DQA:	Date:	
			<del></del>	
ICD. Van / Na	MADE OPPED NON CONFORMANCE / LIDDATE			

NCR:	Yes	/ No				WORK ORDER NON-	CON	FORM	MANCE / UPI	DATE				
					<del>-</del> · · · · · · · · · · · · · · · · · · ·						QA Closed:	Dat	e:	
Marila Ord						DISPOSITION	-			AGAINST DE	PARTMENT	/PROCESS		
Work Orde	er: <sub>-</sub>				<del></del>	Danie de la	- I		Child Auto -	C	1	Water let		
Dart N	N.					Rework	-		Skid-tube	Crosstube Small Fab	Dwa	Water Jet	Engineering	
Part N	۷O				·	Scrap Use-as-is	-		Machining		ł	d. Eng. Coor.	Quality Other	
NCR 1	No.					Work Order Update	-		Large Fab	Finishing Composite	l kec/stoi	re/Packaging Supplier		
i iicii i	•0.				·	Work Order opdate	-		corge rab	composite	]	Supplier		
Root				{	Descri	ption of work order update	Ir	Initial Action			Sign &			
Cause		Date	Step	Qty	(	or Non-conformance	Chi	Chief Eng Description			Date	Verification	QC Inspector	
Doc/Data														
Equip/Tooling			]				-		1		1			
Operator 🖟 🧻									!					
Material *	Ш								!					
Setup	Ш				1									
Other	Ш								1					
Process	Ш								!		:			
Supplier	Ш				-									
Training	Ш								!					
Unapproved	Ш		<u> </u>		<u></u>	· · · · · · · · · · · · · · · · · · ·					<u> </u>			
							AULT	CATE	GORY					
Landi					_	General			!		1	г		
	—	Bending	_			Bend	<del></del>	Grain		-	Ovalized		Pressure/Forced	
	-	Centre No	ot Concei	ntric to	o/s	BOM/Route	-	Hardwa		_	Over/Under	<b>+</b>	Temperature/Cure	
	-	Cracks			<u> </u>	Broken/Damaged	$\vdash$		ion incomplete	–	Part Incorre	<b>.</b>	Weld	
	${m  o}$	Crushed/	Crimped.		<u> </u>	Burrs			tions Incomplete/l	Unclear	Part Lost/M	issing [	Wrong Stock Pulled	
	Н	Cuffs			<u> </u>	Contamination			enance		Part Moved			
		Heat Trea			<u> </u>	Countersink	$\vdash$	Mislabe		<u> </u>	Positioned V			
		Inspection		fube	<u> </u>	Cut Too Short	_	Misread	d 🕆		Power Loss/	Surge [	Other	
		Ripples in			<u> </u>	Drill Holes		Offset	<b></b>					
	Torque Waves in Extrusion				n	Drawing			Calibration					
		Turning Sequence				Finish	Out of Sequence							

Outside Dirnensions

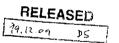
Wave/Twist in Tube

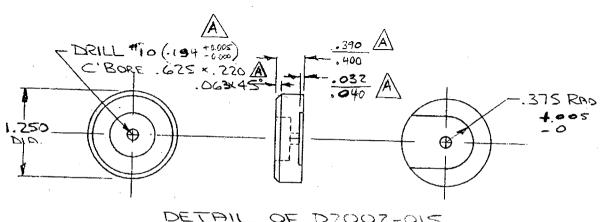
Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	95655
Description: Knob	Part Number:	D2002-015
Inspection Dwg: D2002-015 Rev: A		Page 1 of 1

	FIRST ARTICLE INSPECTION CHECKLIST													
			X First Ar	ticle [	Pro	totype								
D	rawing	Tolerance	Actual	Accept	Reject	Method		Comments						
Dir	nension	7 0 7 0 1 0 1 1 0 0	Dimension	Лоосрі		Inspection	on.							
	1.250	+/-0.010	1.219			12 - 5	<b></b>							
	0.194	+0.005/-0.000	176											
0.62	5 x 0.220	+/-0.010	·626x,21	9										
0.0	63 x 45°	+/-0.010 x 0.5°	.068 x46	1										
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Meas	ured by:	04	Audited by:	,73°	,	Prototype	Approval:	N/A						
	Date:	3.2.	Date:	13/2,	/2		Date:	N/A						
Rev	Date	Change				Т	Revised by	Approved						
Α	08.09.05	New Issue		***		KJ/DD								





THAT COPY 655 3NTO -JINFERING \* (ROLLED COPY A THE MONDMENT ORDER 95.655 MCJ 13-01-16

DETRIL OF DZOUZ-QIS

BLACK DELRIN OR A BLACK UHMW PER D2689



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		_&_	REVISION		I mercen			PART NO.	1 1				ذ ا
ł		<b>X</b>	DRAWN	THIS CHAMMOUS PRIVATE AND COMPRESSION AND IS SUPPLIED ON THE ENTRESS COMPRESS IN IT IS NOT TO BE USED FOR MY PURPLISE OR COPIED OR COMMANMENTATED TO MY DIRECT PRIVATE TO MY DIRECT PRIVATE OR COMMANMENT OF MY DIRECT PRIVA	AVE CODE S	HALL BE PER NAS 523	OTV REQUIRED  APPROVAL	COMPACT NO.	ПЕМ	DESCRIPTION .	MATERIAL	SPEC_/VENDOR	12
ł		9	CHECKED	WENDER THE PERMITSION OF CART AERO.	MARC COOK	DIA DASH NO PHYSIAD MEAN SIDE I-HEAD FAN SIDE	. ATTIOVAL	COMME TAD.		מגם	T AFRO ACCRECATE		Tи
- 1		. <u>A</u>	APPROVED	REQUIREMENTS — UNLESS OTHERWISE SPECIFIED		<del></del>		E RADLI -	DATE		T AERO ACCESSOR	IES INC	1.
		Ē	DESCRIPTION	GENERAL LOANS  1. OWNERSONS ARE DISPOSES  1. TOUGHASTONS	DIGITANO OF SHEE	TE LENGTH DASH NO WYSTERWELD		OCSCH C	31.34	CO COLOR			1
-1		3 5	OF.	3. SURCE ROUGHESS IN.		SIC CODES	1	BRADUE	7 9101.0	28	10		1
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